



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 171793



Part No: D2563

Job Qty: 6 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/5/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/2/18	0.00	0.00	Start Up Large Fab-2		D.M.L 18-2-5
100	Large Fab	6 pcs		2/2/18	0.00	8.82	Large Fab 2		CPC
110	QC	6 pcs		2/2/18	0.00	0.00	QC9		PD 18-02-20
120	QC	6 pcs		2/2/18	0.00	0.00	QC5		PD 18-02-20
130	HandFinish	6 pcs		2/2/18	0.00	1.61	HandFinish1		18-02-20
140	QC	6 pcs		2/2/18	0.00	0.00	QC7		CPC
150	Large Fab	6 pcs		2/3/18	0.00	8.82	Large Fab 2		CPC
160	QC	6 pcs		2/3/18	0.00	0.00	QC10		PD 18-02-22
170	QC	6 pcs		2/3/18	0.00	0.00	QC5		PD 18-02-22
175	HandFinish	6 pcs		2/3/18	0.00	1.61	HandFinish2		18-02-23
180	Powdercoat	6 pcs		2/3/18	0.00	1.00	Powdercoat1		DE 18-2-26
190	HandFinish	6 pcs		2/5/18	0.00	1.61	HandFinish3		DE 18-2-26
200	QC	6 pcs		2/5/18	0.00	0.00	QC3		DE 18-2-26
210	Packaging	6 pcs		2/5/18	0.00	0.00	Packaging3		Smf
220	QC21-SA	6 Ea		2/5/18	0.00	0.00	QC21		DE 18-2-26

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & DESCRIPTIONS: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M 138467 START: 9:20 ALT: 320 FINISH: 9:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	6 Ea (1 ea)	90-Start up Operation	5014552
D2561	Lug	12 Ea (2 ea)	90-Start up Operation	5041761
D2564	Mounting Angle	12 Ea (2 ea)	90-Start up Operation	5042481 + 9 F166325 X3
D2673-34	End Plate	5016496 X 1 Ea (1 ea)	90-Start up Operation	F160473 + 4 5016496
D2673-34	End Plate	6 Ea (1 ea)	150-Large Fab	5016496 → 5 F160473 → 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	6	177	0
	D2561	12	18	0
	D2564	12	3	0
	D2673-34	6	12	0
	D2673-34	6	12	0

89.700

Plex 2/8/18 2:20 PM Dart.Gagnon.Michelle

Part Specifications	
Specifications could not be found.	

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Container No: S042577



Step Weldment Assembly

PART NO: D2563

Serial No/Batch: S042577

Revision:

Operation: Start up Operation 02/15/18

Change No:

Job No: 171793